

Work Order ID 85247***85247***

June-05-12 9:10:40 AM

Page 1

Item ID: D412-742-043

Accept.

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Replacement Float Skidtube

Start Date: 05/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 19/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: M L J.

Date: 12/06/05 Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	1								
100		0.00							

100

DOCUMENT CONTROL

DC

Document Control

Memo

0.00

If D412-742-043 is a W/O on its own,
Photocopy bluefile and create labels per PPP D412-742-043 CHG005*N/A*

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Page 2

Item ID: D412-742-043

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Replacement Float Skidtube

Stop

NS2Start Date: 05/06/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 19/06/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

110

HandFinish

Hand Finishing

HandFinishing

0.00

1x 4 316/14

Memo 0.00
 1-Install tubes together and seal them all the way around using Sikaflex
 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using
 7/16" "T" Pins.
 A/RSikaflex-241/291 111469
 Expiry date: 13162

2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against
 wearplate, then topped with the SS washer. Seal all bolts with sikaflex except
 ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.

A/RSikaflex-241/291 111409
 Expiry date: 13163

3-Remove "T" pins once sikaflex is dry.

4-Coat all exposed hardware with LPS Procyon. Remove any excess off with
 MEK degreaser.

A/RLPS Procyon 1114576

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Item ID: D412-742-043

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Replacement Float Skidtube

Stop

NS2

Start Date: 05/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 19/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
Description

120

QC5- Inspect part completeness to step on W/O

120

QC

Quality Control

Memo

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

Enthaler

0.00

130

130

Packaging

Packaging

0.00

PPP 85585

Latvia

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D412-742-043

Location: _____

PPP Rev: _____

140

140

QC

QC21- Final Inspection - Work Order Release

0.00

0.00

Quality Control

Memo

12/6/12 JJ

MF
12-06-12

Picklist Print

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Page 1
3

Work Order ID: 85247

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

85247
D412-742-043

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev A 05.10.13	New Issue	KJ/JLM
IPP Rev 06.02.13	ECN 773 dwg @ rev.D	EC
IPP Rev:C 07-05-28	As per Rev F	JLM
IPP Rev:D 07-12-04	ECN 1072	DD verified by:JLM
IPP Rev:E 08-09-08	ecn 08-510	DD verified by:EC
		IPP Rev:F
11.11.01 as per DSI9517 REV.B DD verified by:EC		

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3391-021 <i>*D3391-021*</i>	A	Manufactured	No			110	Each	0.0000	1	1			**
Fwd Tube Assembly				<i>used on -023</i>	<i>\$85158</i>								
D3391-023 <i>*D3391-023*</i>		Manufactured	No			110	Each	0.0000	1	1			**
Mid Tube Assembly													

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
			FP	1		
			GA	-1		
D3391-025 <i>*D3391-025*</i>		Manufactured	No			110
Aft Tube Assembly						Each
AN3C4A <i>*AN3C4A*</i>		Purchased	No			110
BOLT						Each

		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
		ST350	1362		
		120187	57		
		120521	28		
		120769	38		
		121205	1000		
		121556	239		
				x74	

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Other <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/>											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector						
Doc/Data																	
Equip/Tooling																	
Operator																	
Material																	
Offset/Setup																	
Other																	
Process																	
Supplier																	
Training																	
Unauthorized																	
FAULT CATEGORY																	
Landing Gear <input type="checkbox"/> Bending Passes Below Min <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimp at Bending <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Other <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Ripples on Inner Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				Hardware <input type="checkbox"/> Breaking <input type="checkbox"/> Missing <input type="checkbox"/> Size/Length <input type="checkbox"/> Spinning <input type="checkbox"/> Threading <input type="checkbox"/> Wrong		General <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Documentation/Data <input type="checkbox"/> Finish <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Inspection Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Jigs/Fixtures/Tooling <input type="checkbox"/> Kit Incorrect <input type="checkbox"/> Kit Missing		<input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Off-Set <input type="checkbox"/> Orientation Misread <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Lost <input type="checkbox"/> Part Moved <input type="checkbox"/> Raw Material				<input type="checkbox"/> Set-up <input type="checkbox"/> Supplier <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other					
				Drill Holes													
				Misaligned													
				Ovalized													
				Over/Undersized													
				Too Many													

Picklist Print

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Page 2

Work Order ID: 85247

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

85247

D412-742-043

Start Date: 05/06/2012

Start Qty: 1.00

Required Date: 19/06/2012

Required Qty: 1.00

AN3C6A

Purchased

No

110

Each

451.0000

10

10

**

AN3C6A

BOLT

HL

120611

Location	Loc Qty	Loc Code
----------	---------	----------

FP001	1	
-------	---	--

111982	1	
--------	---	--

ST351	450	
-------	-----	--

111982	2	
--------	---	--

116419	23	
--------	----	--

116549	2	
--------	---	--

116704	12	
--------	----	--

117619	10	
--------	----	--

117688	1	
--------	---	--

117872	5	
--------	---	--

118422	13	
--------	----	--

119449	21	
--------	----	--

120423	3	
--------	---	--

120693	158	
--------	-----	--

121682	200	
--------	-----	--

X10

AN3C7A

Purchased

No

110

Each

140.0000

4

**

AN3C7A

BOLT

HL

120611

Location	Loc Qty	Loc Code
----------	---------	----------

ST351	140	
-------	-----	--

113149	14	
--------	----	--

116169	1	
--------	---	--

117313	10	
--------	----	--

117619	12	
--------	----	--

117688	6	
--------	---	--

119749	1	
--------	---	--

120731	8	
--------	---	--

121185	50	
--------	----	--

121541	38	
--------	----	--

SC

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS						
			Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Engineering Quality <input type="checkbox"/>			
Part No. _____			Work Order Update <input type="checkbox"/>	Machining <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Supplier <input type="checkbox"/>	Other <input type="checkbox"/>			
NCR No. _____				Finishing <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>						
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data												
Equip/Tooling												
Operator												
Material												
Offset/Setup												
Other												
Process												
Supplier												
Training												
Unauthorized												
FAULT CATEGORY												
Landing Gear <input type="checkbox"/> Bending Passes Below Min <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimp at Bending <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Other <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Ripples on Inner Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				Hardware <input type="checkbox"/> Breaking <input type="checkbox"/> Missing <input type="checkbox"/> Size/Length <input type="checkbox"/> Spinning <input type="checkbox"/> Threading <input type="checkbox"/> Wrong Drill Holes <input type="checkbox"/> Misaligned <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Undersized <input type="checkbox"/> Too Many			General <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Documentation/Data <input type="checkbox"/> Finish <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Inspection Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Jigs/Fixtures/Tooling <input type="checkbox"/> Kit Incorrect <input type="checkbox"/> Kit Missing				<input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Off-Set <input type="checkbox"/> Orientation Misread <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Lost <input type="checkbox"/> Part Moved <input type="checkbox"/> Raw Material	
											<input type="checkbox"/> Set-up <input type="checkbox"/> Supplier <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	
											<input type="checkbox"/> Other	

Picklist Print

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Work Order ID: 85247

85247

Parent Item: D412-742-043

D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN960C10L	NAS1149C0332 R	Purchased	No	110	Each	0.0000	38	38
-----------	-------------------	-----------	----	-----	------	--------	----	----

*AN960C10I *

washer

M121509 ** (x38) JL 120611

D4095-041

Manufactured

No

110 Each 0.0000

**

381623 (x1) JL 120611

D4095-041

Wearplate Assembly

D4095-043

Manufactured

No

110 Each 1.0000

**

381624 (x1) JL 120611

D4095-043

Wearplate Assembly

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP001	1	
	1	

D4095-045

Manufactured

No

110 Each 15.0000

**

JL 120611

D4095-045

Wearplate Assembly

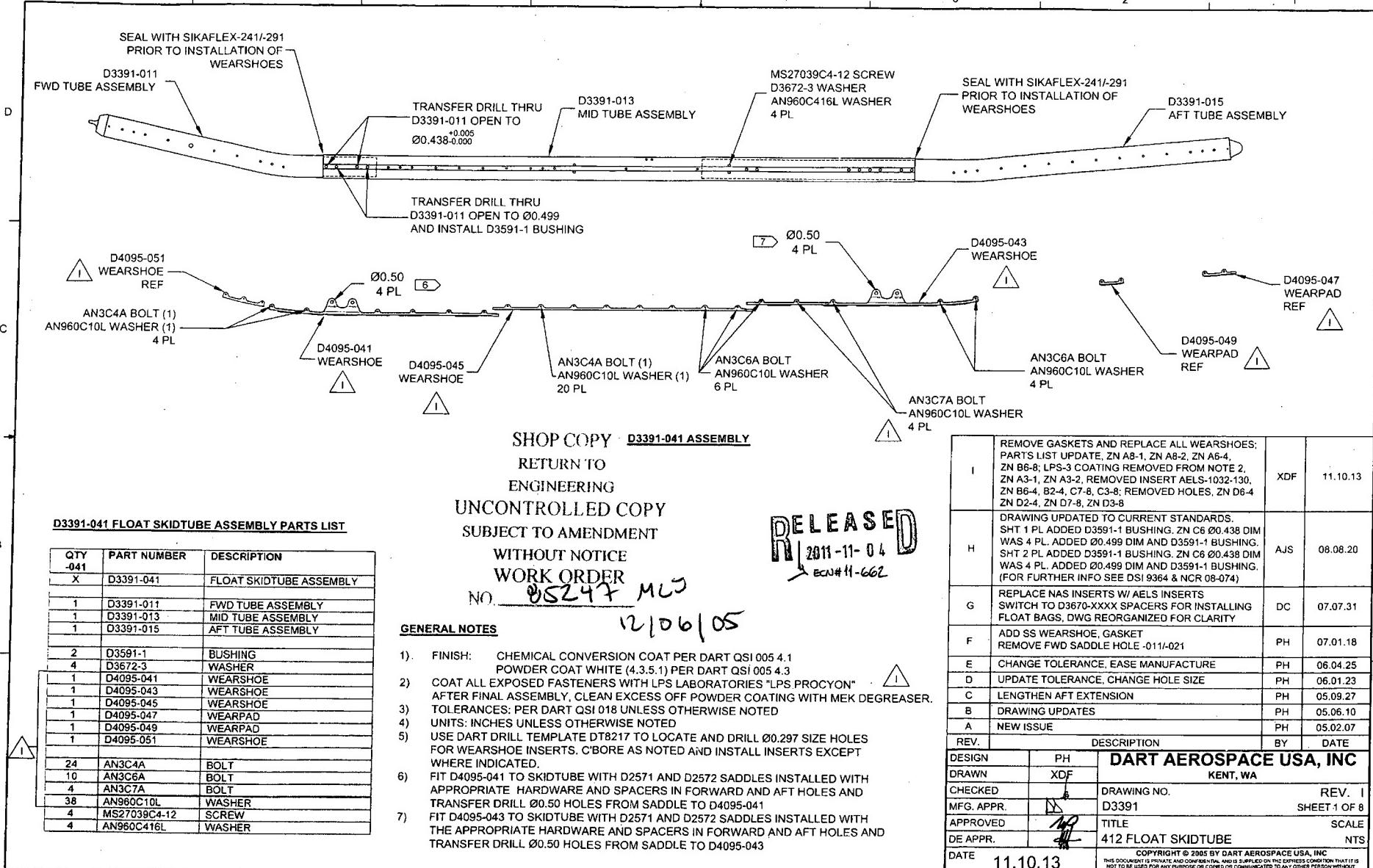
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP	1	
	1	

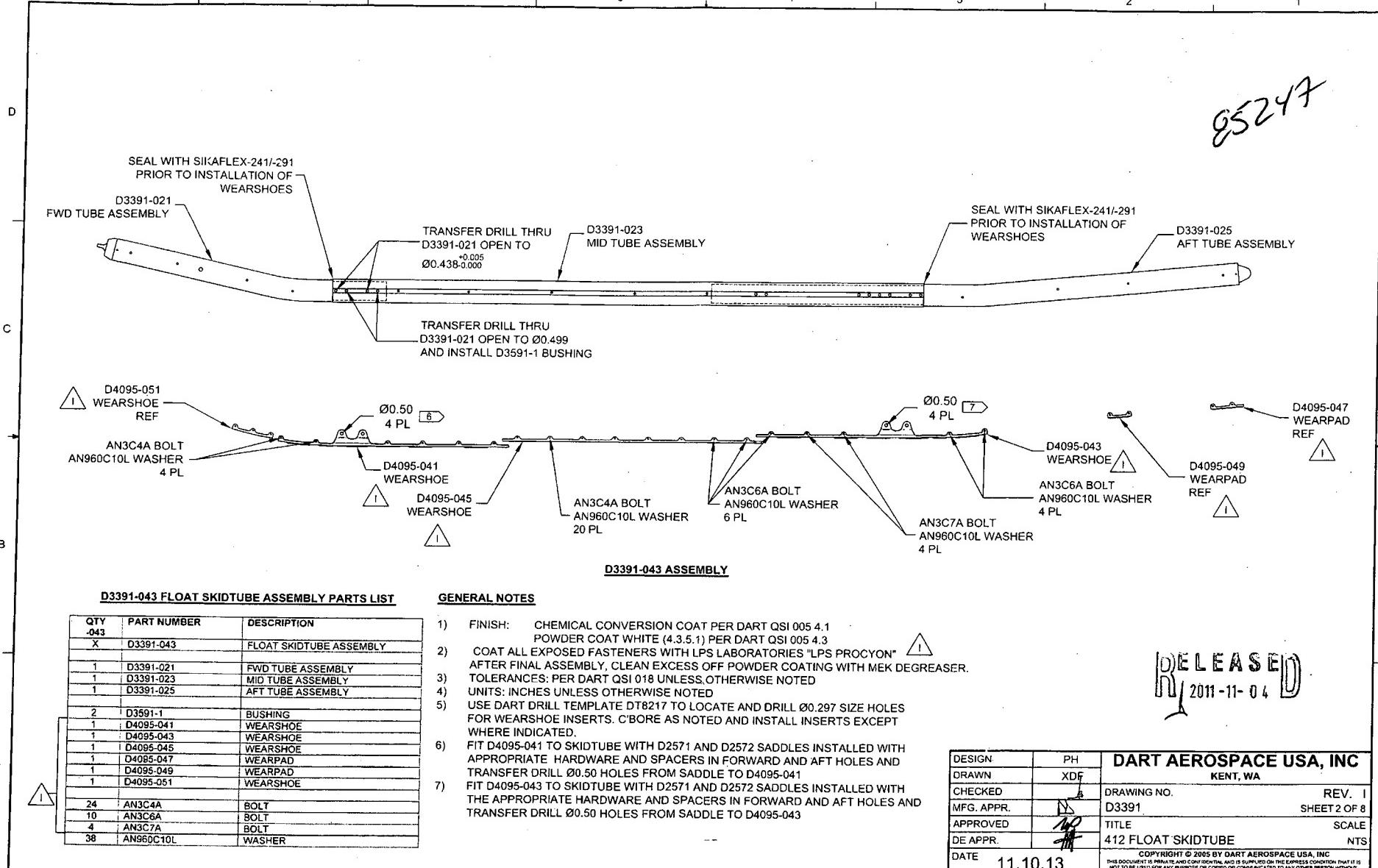
81625	1	
FP001	14	

77737	1	
-------	---	--

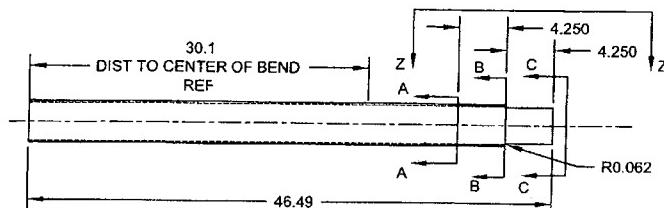
84081	13	
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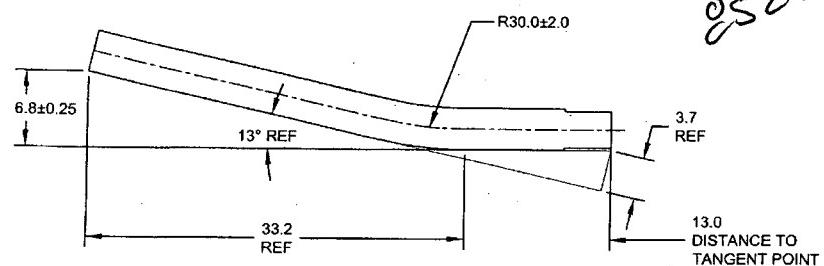
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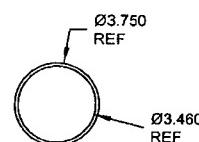
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DE APPR.	b	412 FLOAT SKIDTUBE	NTS
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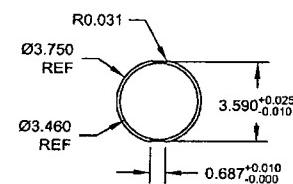
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



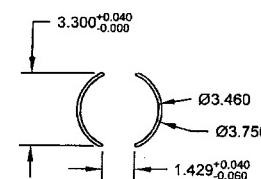
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



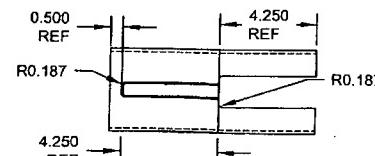
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SCALE 2X



SECTION B-B



SECTION C-C

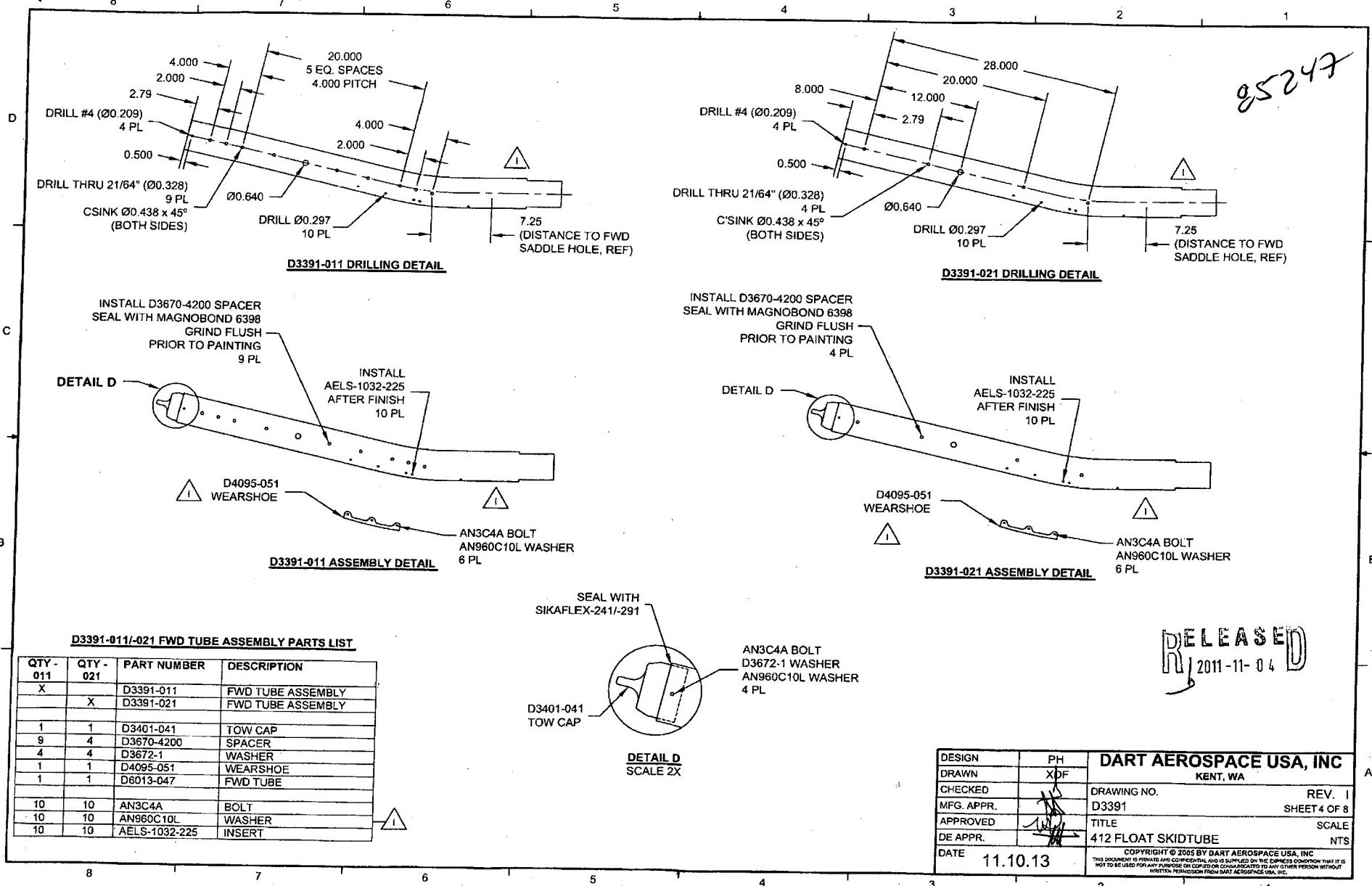


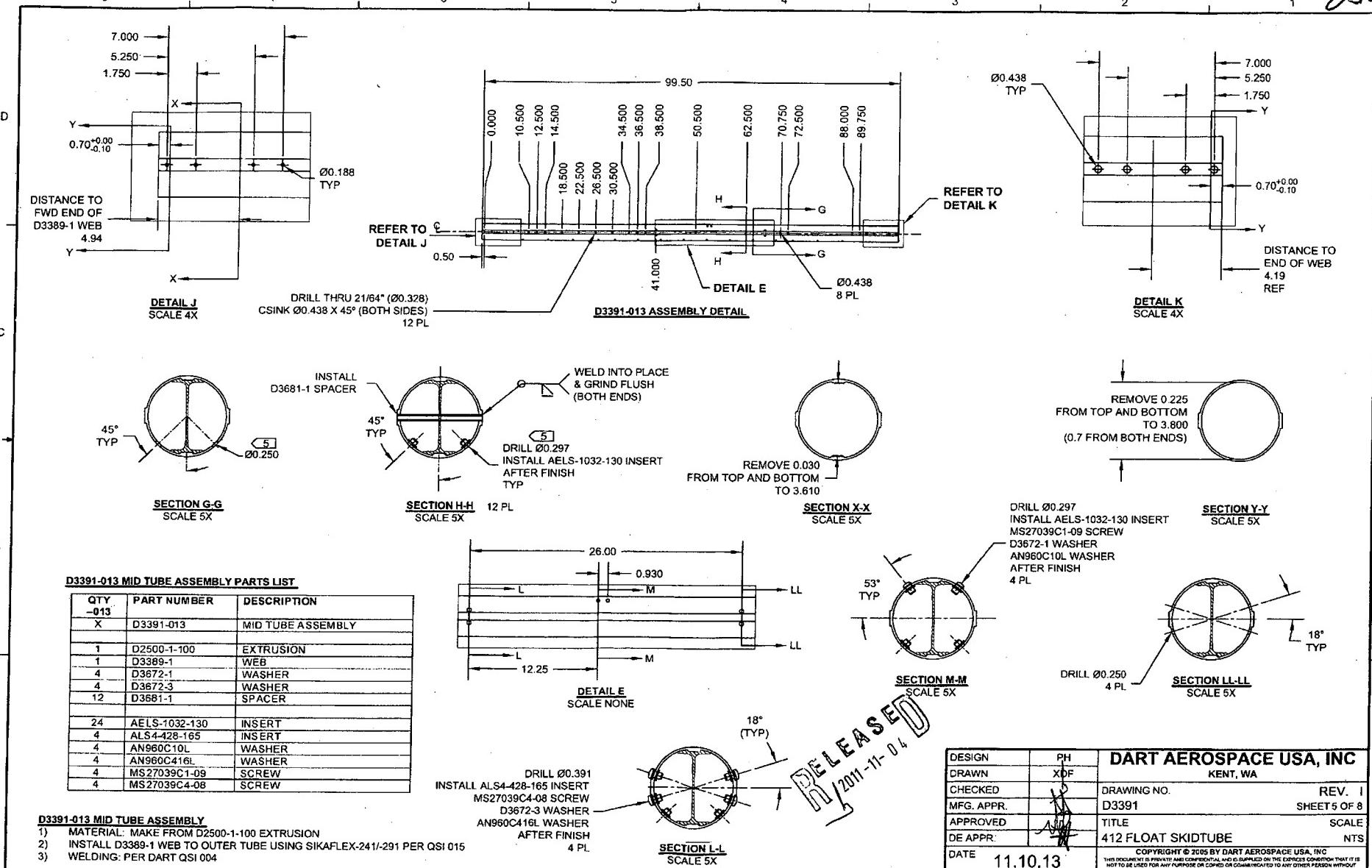
VIEW Z-Z
SCALE 2X

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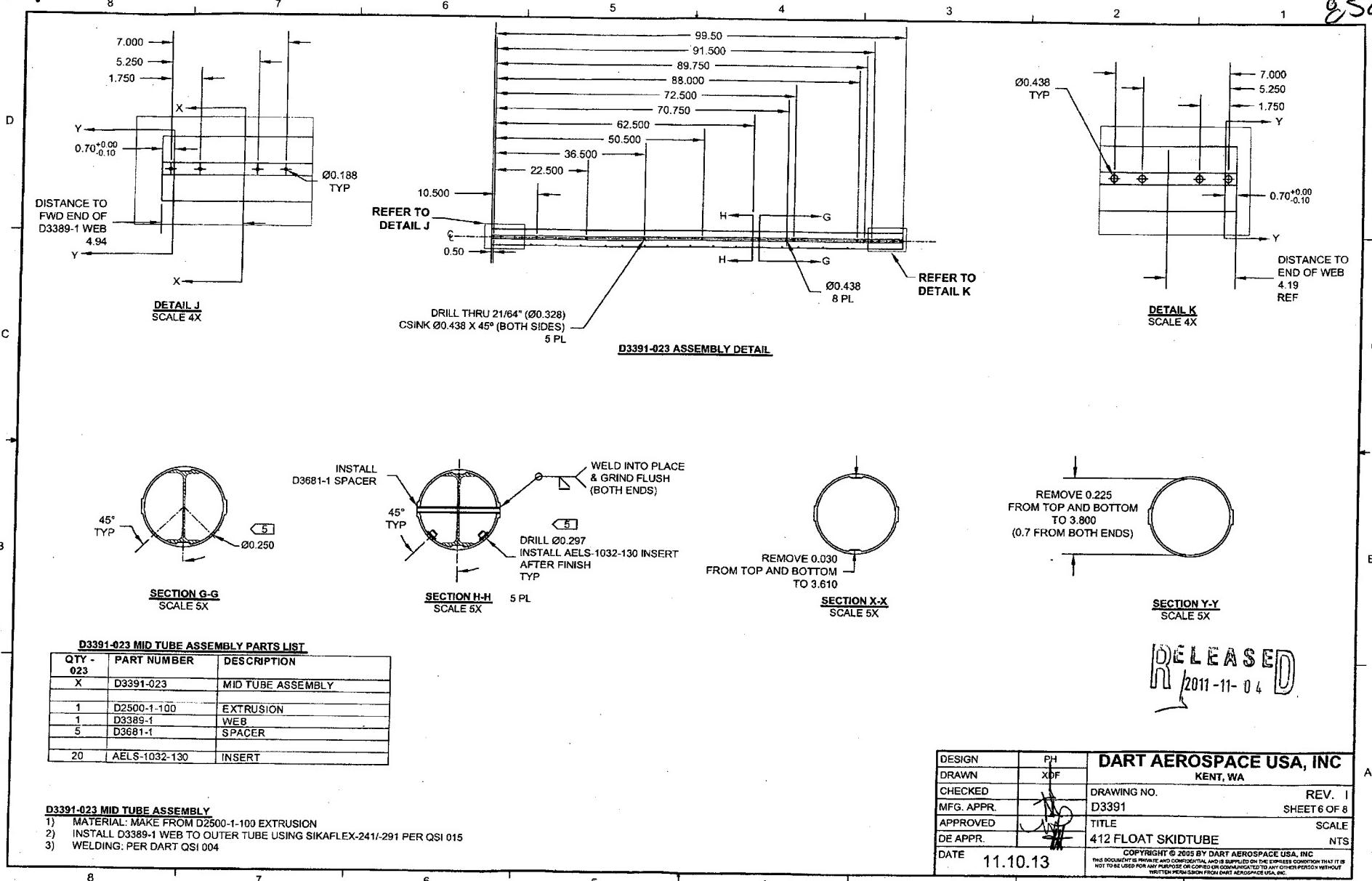
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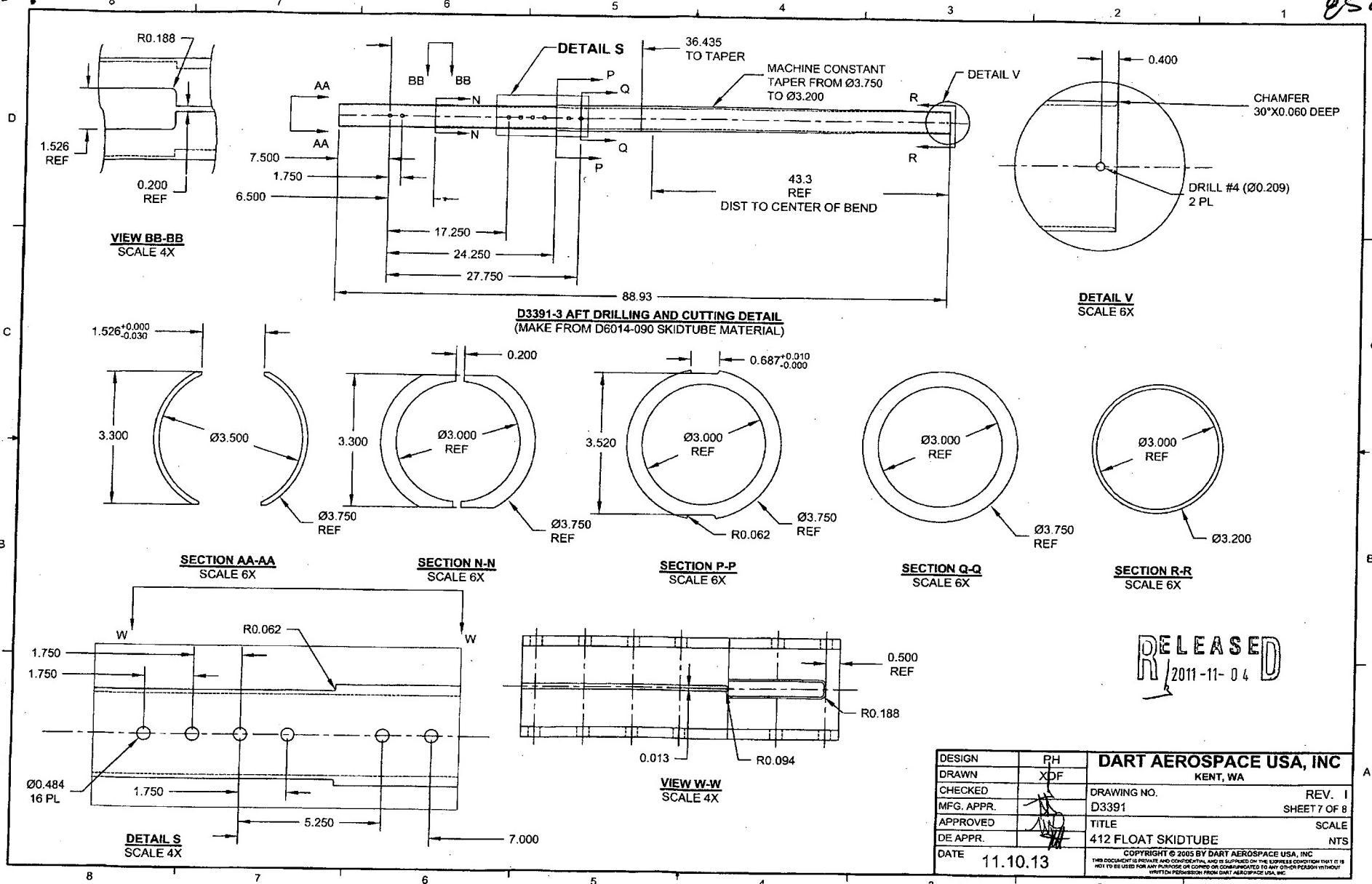




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DE APPR:		DATE 11.10.13	

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DATE	11.10.13

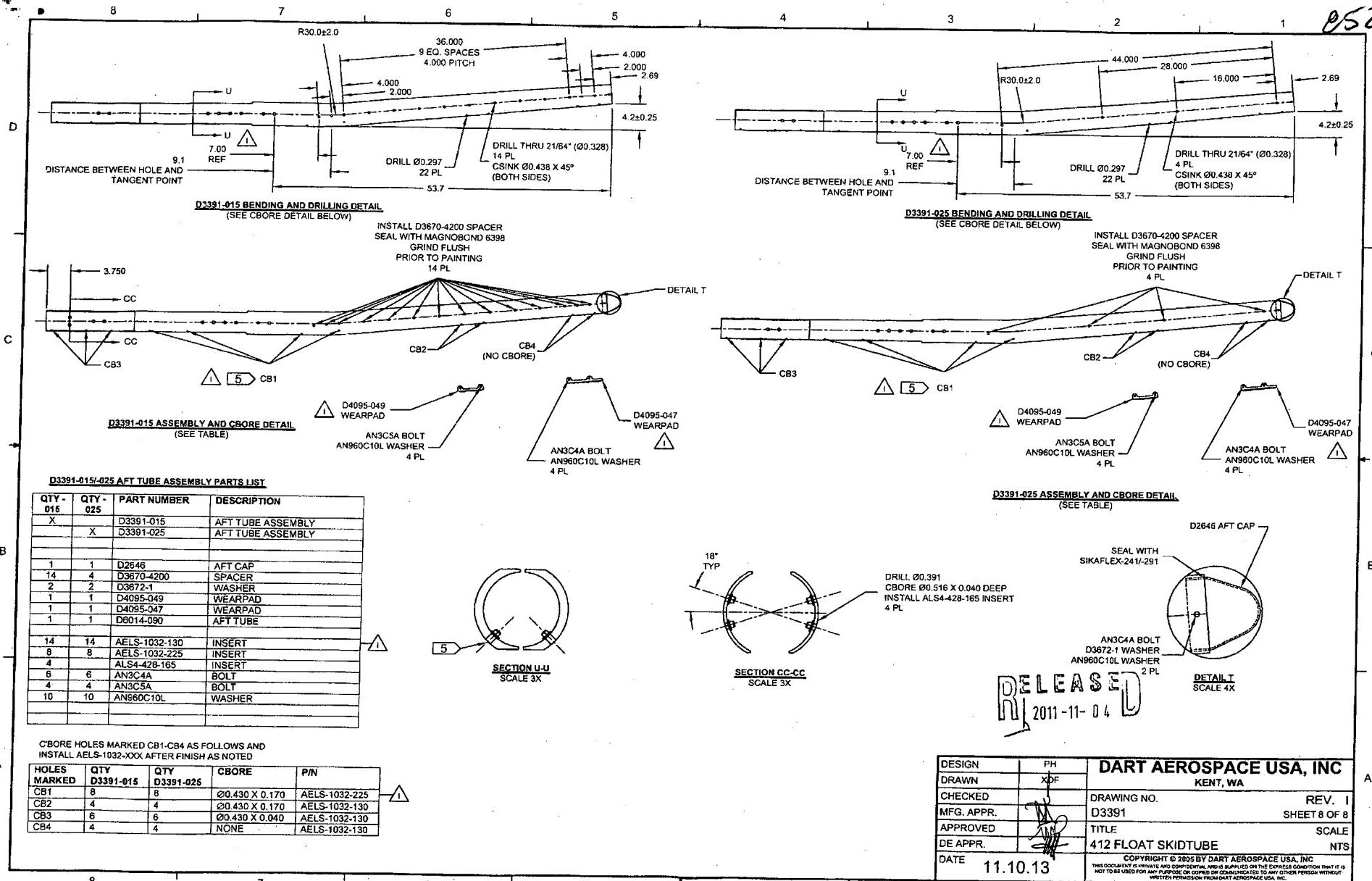
DART AEROSPACE USA, INC
KENT, WA

DRAWING NO. D3391 REV. I
SHEET 7 OF 8

TITLE 412 FLOAT SKIDTUBE SCALE NTS

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05247



CBORE HOLES MARKED CB1-CB4 AS FOLLOWS AND
INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	P/N
CB1	8	8	.00 .430 X .170	AELS-1032-225
CB2	4	4	.00 .430 X .170	AELS-1032-130
CB3	6	6	.00 .430 X .040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

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